

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007184**Date Inspected:** 20-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Ming, Wan Wen Zhong**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector, George Goulet, randomly observed the following work in progress in Bay 10:

SAW welding of weld joint NSD1-FCSA4-1A/C-61A located on PCMK north tower, lift 4, skin C. Welder was identified as 040252. ZPMC QC was identified as CWI Liu Yang (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Shi Jing Wei, who was not a CWI. The welding variables recorded by QC1 and his assistant appeared to comply with WPS-B-T-2221-B-U3c-S-2.

SAW welding of weld joint NSD1-FCSA4-1A/C-58 located on PCMK north tower, lift 4, skin C. Welder was identified as 050295. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Shi Jing Wei, who was not a CWI. The welding variables recorded by QC1 and his assistant appeared to comply with WPS-B-T-2221-B-P3-S-2.

SAW welding of weld joint NSD1-FCSA4-1A/C-19A located on PCMK north tower, lift 4, skin C. Welder was identified as 051413. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Shi Jing Wei, who was not a CWI. The welding variables recorded by QC1 and his assistant appeared to comply with WPS-B-T-2221-B-U3c-S-2.

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FCAW welding of weld joint NSD1-FASA3-1E/E-45-A located on PCMK north tower, lift 3, skin A which was mounted on an A-frame. Welders were identified as 053869. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Sun Tian Liang, who was not a CWI. The welding variables recorded by QC1 and his assistant appeared to comply with WPS-345-FCAW-1G(1F)-repair.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above, and this QA Inspector, George Goulet, asked each QC if all the welding variables observed by him appeared to comply with the appropriate WPS, including the preheat requirements according to thickness of the thickest member being welded. Each QC showed this QA Inspector, George Goulet, that he was carrying the proper temperature sticks to monitor the minimum and maximum preheat and interpass temperatures and replied that all he observed did appear to comply.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

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| Inspected By: | Goulet, George | Quality Assurance Inspector |
| Reviewed By: | Carreon, Albert | QA Reviewer |
